

A B S T R A C T

A carcass ply (3) is formed by laying down on a toroidal support (11), a first and a second series of strip-like sections (13, 14) cut to size from a continuous strip-like element* (2a) and each comprising longitudinal thread-like elements (15) incorporated into a layer of elastomer material (18). The sections (13) of the first series are sequentially laid down circumferentially spaced apart a given distance from each other, to form side portions (13a) to the end flaps of which respective reinforcing structures (4) at the beads are applied. The sections of the second series (14) are each interposed between two sections of the first series (13), in spaces therein defined, with the respective end flaps overlapping the annular structures (4). Each annular portion (4) comprises an elastomer filling (22) applied to a radially outer position relative to a single annular anchoring insert (21) formed of at least one elongated element wound up into radially superposed concentric coils (21a).

Fig. 1.